

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012187**Date Inspected:** 18-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG # TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress:

Segment# 7AW-PP49

This QA inspector observed, ZPMC qualified welding personnel identified as 068917 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SP124-001-037; ZPMC CWI is identified as Mr.Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2213-B-U2. See the attached below Photo

Segment # Cross Beam-6/ 6CE-PP45

This QA inspector observed, ZPMC qualified welding personnel identified as 066261 perform Shielded Metal Arc Welding (SMAW), weld joint identified as FB032-001-128; ZPMC CWI is identified as Mr.Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2212-TC-U4b-FCM-1. See the attached below Photo.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Segment # Cross Beam-6/ 6CE-PP45

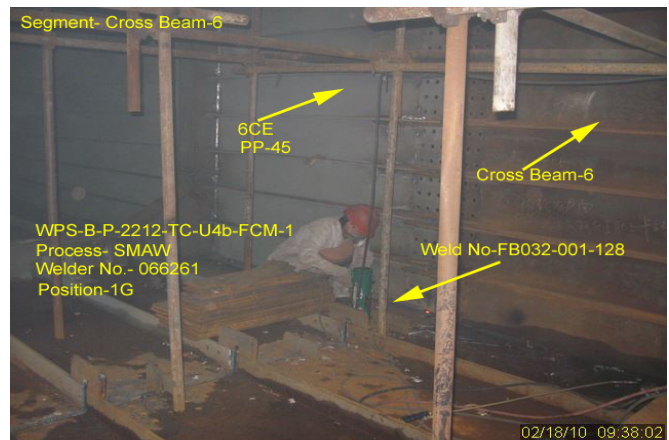
This QA inspector observed, ZPMC qualified welding personnel identified as 067665 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SSB17-PP45-166; ZPMC CWI is identified as Mr.Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2114.

This QA inspector observed, ZPMC qualified welding personnel identified as 220066 perform Flux Core Arc Welding (FCAW), weld joint identified as OBW6F-010; ZPMC CWI is identified as Mr.Li Yang The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2233T.

Segment

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 037743 perform Shielded Metal Arc Welding (SMAW) , weld joint identified as SEG027F-008; The Welding Repair Report (WRR) was B-WR10627. ZPMC QC is identified as Mr.Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-1G (1F) Repair.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Prabhune,Manoj

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer